

31

Date: Tuesday, 6/26/2007 3:10:06 PM
User: Kim Johnston

Process Sheet

| | |
|---------------------------------------------------------------------------------------|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 206L FWD X-TUBE |
| Job Number : 33154 | |
| Estimate Number : 10553 | |
| P.O. Number : | Part Number : D206667103BL |
| This Issue : 6/26/2007 S.O. No. : | Drawing Number : D206-667-143 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 1 / | Drawing Revision : B |
| Previous Run : 32667 | Material : |
| Written By : | Due Date : 7/30/2007 Qty: 1 Um: Each |
| Checked & Approved By : <u>JA 07.06.27</u> | |
| Comment : Est Rev: F 95.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

En 07/08/12

| | | |
|-----|----------|--------------------|
| 2.0 | D6002115 | Crosstube material |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | |
|-----------------|-------------|-------|
| Qty Part number | Description | Batch |
|-----------------|-------------|-------|

| | | | |
|---|-----------|-----------|--------------|
| 1 | D6002-115 | Crosstube | <u>29113</u> |
|---|-----------|-----------|--------------|

Check OD = 2.250"; ID = 1.750"

BC 07-07-17 (1)

| | | |
|-----|------------|----------------------------|
| 3.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

BC 07-07-17 (1)

| | | |
|-----|-----|------------------------------|
| 4.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET

BC 07-07-17 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:10:06 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 33154

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

SG 07.07.17

①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SG 07.07.17

①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 07/07/17

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 7-7-23

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ED 07/07/23 (41)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

h 7-7-23

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

DP 7-8-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng./ Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:10:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 33154

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

EP 07/08/13 (+1)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

7-8-13

ELP
JD 7-8-13

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 07-08-14

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

IT 07 08 14

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 33154

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 4353 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

CL07/08/14 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

7/8/15 SP

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

Er 07/06/15 ④

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

ml 070815

2-Paint outside crosstube DELFLEET BLUE

Er -> Rec'd By SP 7/8/15

3-CLEAR WITH DELFLEET

ISSUE P.O TO ATELIER DEBOSSSELAGE

4367 CL07/08/16 ①

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

Er 07/02/17

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description

Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

32020

ml 070818

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:10:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 33154

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

32802

25 07-08-16

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

32164

25 07-08-16

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

33738

ml 07 08 20

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

102850

25 07-08-16

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

104902

ml 07 08 20

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (2) Aft holes should be facing up.

ml 07 08 18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:10:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 33154

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

ml 07-08-18

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

3C 07-08-16

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/20

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104885

SP

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M104116

SP

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-7A

Description Batch

Bolt M104374

SP

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt M104374

7/8/20 SP

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:10:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 33154

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M10415L

7/8/20

SE

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 07/08/20

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: _____

PPP Rev: _____

B

7/8/20

SE EP

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.20

Job Completion



07.08.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|--------------------------------------------------------|---------------------|---------------------|
| DART AEROSPACE LTD | Work Order: | 33154 |
| Description: Crosstube Assembly (206L High Fwd) | Part Number: | D206-667-143 |
| Inspection Dwg: D206-667-143 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

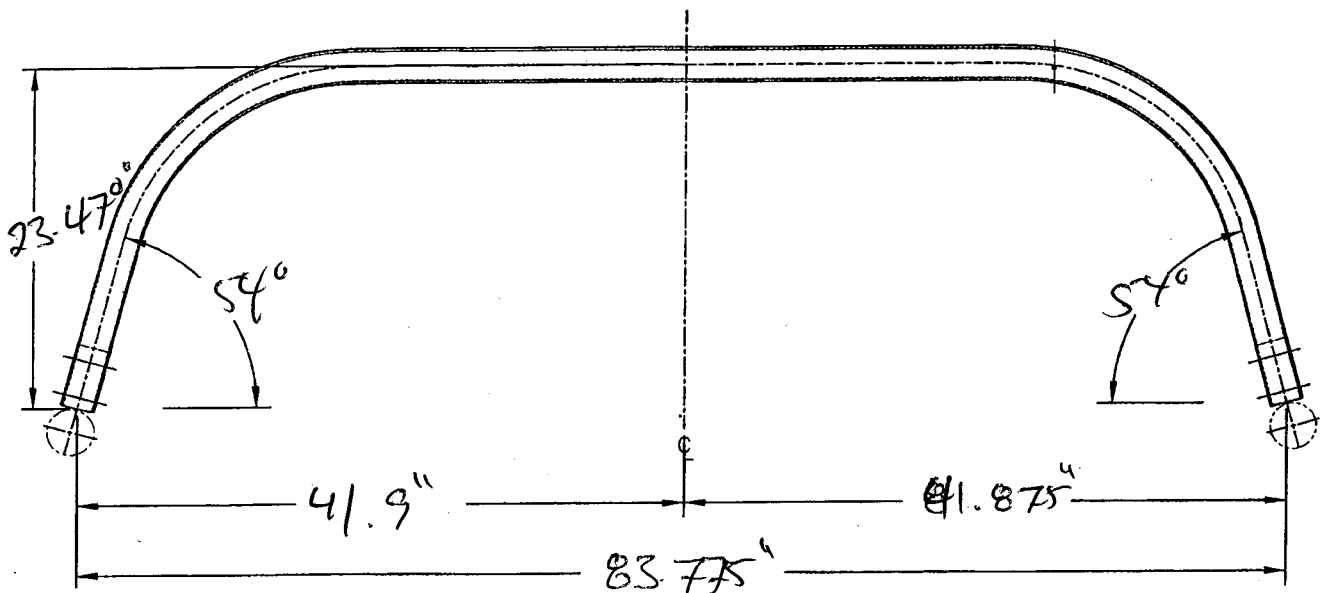
| | Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.245 | ✓ | | | |
| | 1.982 | +0.005/-0.000 | 1.987 | ✓ | | | |
| | 2.019 | +0.005/-0.000 | 2.024 | ✓ | | | |
| | 2.058 | +0.005/-0.000 | 2.063 | ✓ | | | |
| | 2.097 | +0.005/-0.000 | 2.102 | ✓ | | | |
| | 2.136 | +0.005/-0.000 | 2.141 | ✓ | | | |
| | 2.176 | +0.005/-0.000 | 2.181 | ✓ | | | |
| | 2.201 | +0.005/-0.000 | 2.206 | ✓ | | | |
| | | | | | | | |
| | 0.125 | +/-0.010 | .125 | ✓ | | | |
| | 0.400 x 30° | +/-0.010 | .400 | ✓ | | | |
| | R0.063 | +/-0.010 | .063 | ✓ | | | |
| | R0.500 | +/-0.010 | .500 | ✓ | | | |
| | 4.438 | +/-0.030 | 4.438 | ✓ | | | |
| | | | | | | | |
| SIDE B | 104.98 | +/-0.020 | 104.98 | ✓ | | | |
| | 2.240 | +0.005/-0.000 | 2.245 | ✓ | | | |
| | 1.982 | +0.005/-0.000 | 1.987 | ✓ | | | |
| | 2.019 | +0.005/-0.000 | 2.024 | ✓ | | | |
| | 2.058 | +0.005/-0.000 | 2.063 | ✓ | | | |
| | 2.097 | +0.005/-0.000 | 2.102 | ✓ | | | |
| | 2.136 | +0.005/-0.000 | 2.141 | ✓ | | | |
| | 2.176 | +0.005/-0.000 | 2.181 | ✓ | | | |
| | 2.201 | +0.005/-0.000 | 2.206 | ✓ | | | |
| | | | | | | | |
| | 0.125 | +/-0.010 | .125 | ✓ | | | |
| | 0.400 x 30° | +/-0.010 | .400 | ✓ | | | |
| | R0.063 | +/-0.010 | .063 | ✓ | | | |
| | R0.500 | +/-0.010 | .500 | ✓ | | | |
| | 4.438 | +/-0.030 | 4.438 | ✓ | | | |
| | | | | | | | |

| | | | | | |
|---------------------|-----------------|--------------------|-----------------|----------------------------|-----|
| Measured by: | BF | Audited by: | SL | Prototype Approval: | N/A |
| Date: | 07-07-17 | Date: | 07/07/17 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 04.05.06 | New Issue (P/O D206-667-103) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | |

| | | | |
|----------------------------------------|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 33154 |
| Description: Crosstube High Fwd (206L) | | Part Number: | D206-667-103 |
| Inspection Dwg: D206-667-143 Rev: B | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 23.46 | 23.58 |
| 1/2 Span | 41.86 | 41.98 |
| Angle | 54 | 56 |
| Total Span | 83.72 | 83.96 |



| Comments |
|----------|
| |
| |
| |
| |

| | |
|-----------------|----------|
| QC15 Inspection | En |
| Date | 07/08/13 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-------------|
| A | 07.02.06 | New Issue | KJ/JM | [Signature] |



| | | | |
|------------------|-----------------|---------------------------------------------------------------------|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED HDS | APPROVED HDS | DRAWING NO. D206-667-143 | REV. B SHEET 1 OF 3 |
| DATE 05.07.26 | | TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS | |
| A | 00.11.17 | NEW ISSUE | |
| B | 05.07.26 | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |

RELEASED
05-07-26 H

UNDER REVIEW

05-08-10 PH

re-draw detail F
PH

0705-02

| Qty | Part Number | Description |
|-----|---------------|------------------------------------|
| X | D206-667-143 | CROSSTUBE ASSEMBLY (206L HIGH FWD) |
| 1 | D6002-115 | CROSSTUBE |
| 2 | D2873-043 | NUT PLATE |
| 2 | D2873-045 | NUT PLATE |
| 2 | D2856-400-694 | ABRASION STRIP |
| 2 | D2891-1 | SUPPORT |
| 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 4 | MS21920-20 | CLAMP |

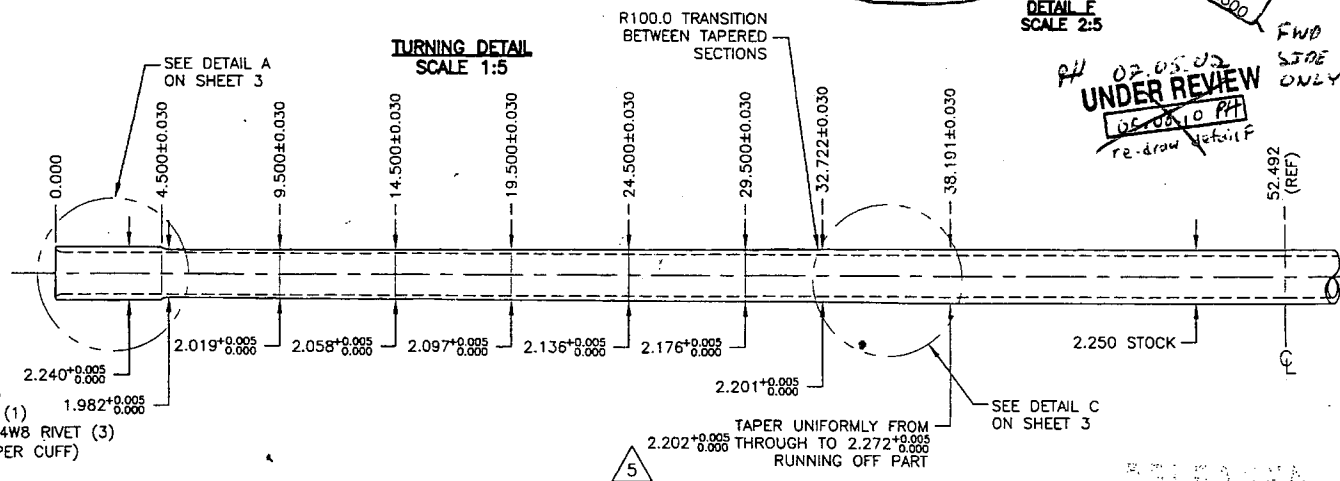
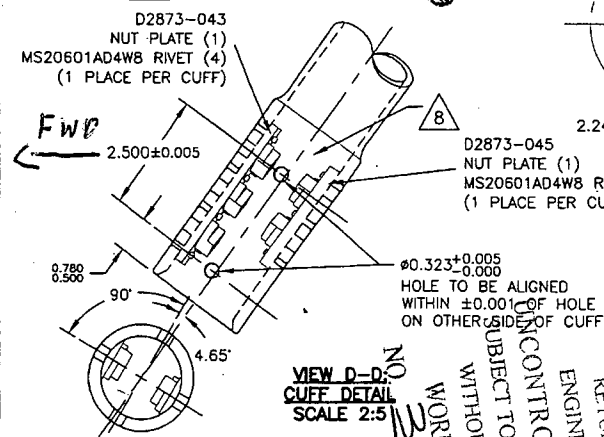
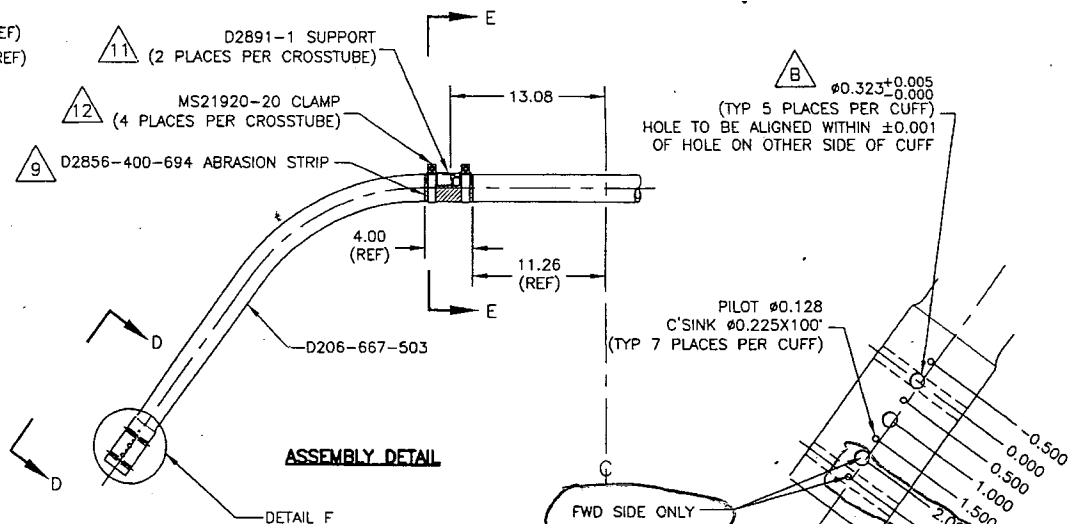
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

STOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33154

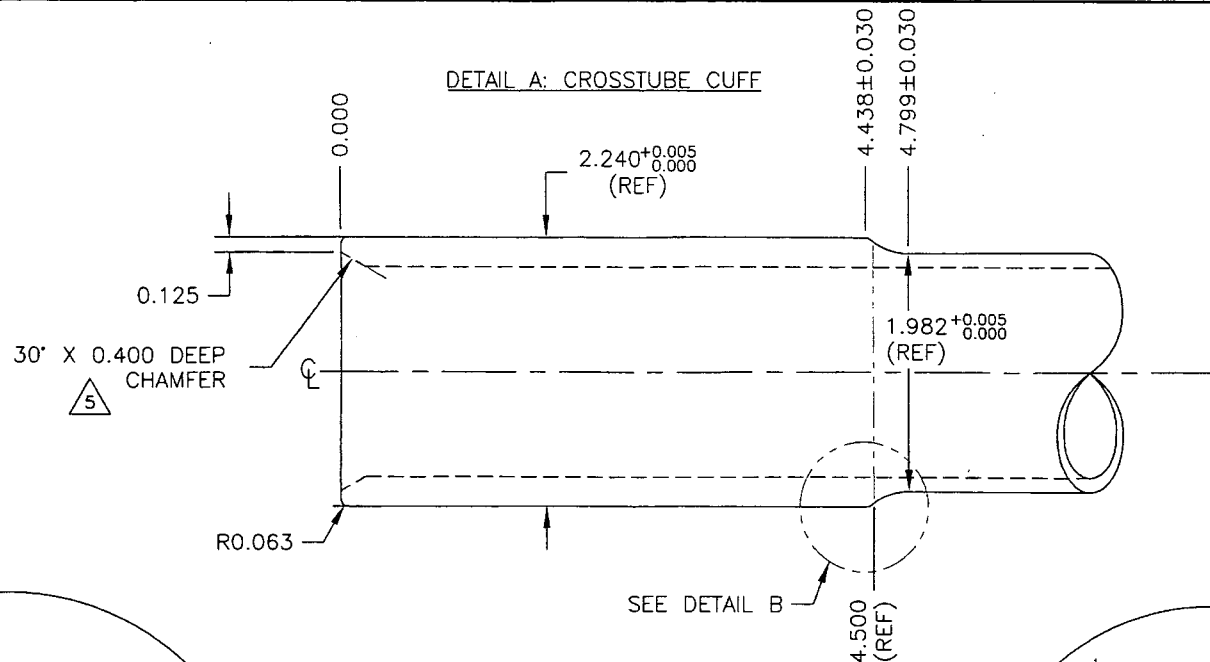
Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



| | |
|---------------------------------|--------------|
| DRAWING NO. | REV. B |
| D206-667-143 | SHEET 2 OF 3 |
| TITLE | SCALE |
| CROSSTUBE ASS'Y (206L HIGH FWD) | 1:10 |

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33154
2/1/90



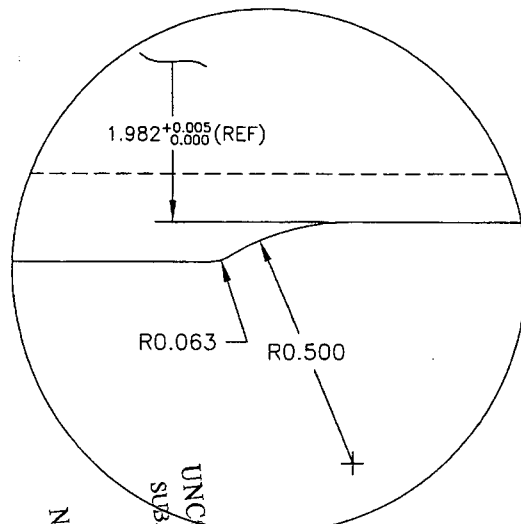
05.07.26

UNDER REVIEW

06.03.10 PH

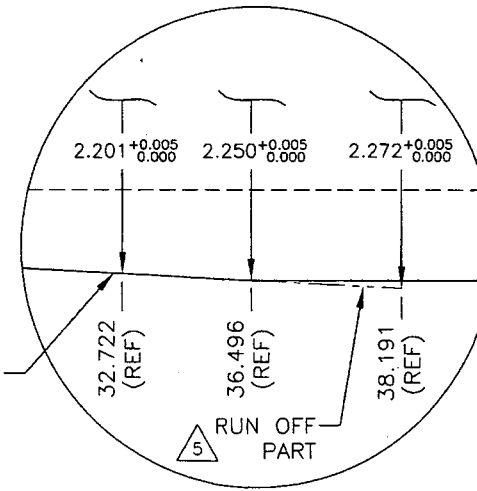
Re-draw detail F

PH 07.05.02



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 33154

WORK ORDER

SHOP COPY

ENGINEERING

RETURN TO

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

| | | | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------|----------------|------------------------------------------------------------------|
| COPYRIGHT © 2000 BY DART AEROSPACE LTD. | | DESIGN PH | DRAWN BY PH | DART DART AEROSPACE LTD. MUMFRESSBURY, ONTARIO, CANADA |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | CHECKED PH DS | APPROVED PH DS | |
| DATE 05.07.26 | | DRAWING NO. D206-667-143 | | REV. B SHEET 3 OF 3 |
| | | TITLE CROSSTUBE ASS'Y (206L HIGH FWD) | | SCALE 1:1 |



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37152

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of four (4) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI-038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (1) P/N D206-667-203 S/N B33689

Qty. (1) P/N D206-667-203BL S/N B33160

Qty. (1) P/N D206-667-103BL S/N B33154

Qty. (1) P/N D206-667-103 S/N B33686

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on four (4) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Four (4) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLETCHER

DATE August 14, 2007

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER

4353

ADDRESS:

CONTACT NAME:

| | | |
|-----------------|---|-----|
| LABOUR | @ | \$ |
| MATERIALS | @ | |
| TRAVEL EXPENSES | @ | GST |
| HOTEL EXPENSES | @ | PST |

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

Date: Tuesday, 6/26/2007 3:10:06 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE
Job Number : 33154
Estimate Number : 10553
P.O. Number :
This Issue : 6/26/2007 S.O. No. :
Prsht Rev. : NC Part Number : D206667103BL
First Issue : 1 / 1 Type : LANDING GEAR Drawing Number : D206-667-143 REVB
Previous Run : 32667 Drawing Revision : B
Material :
Due Date : 7/30/2007 Qty: 1 Um: Each
Written By :
Checked & Approved By : 07.06.27
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell
Skidtubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

07.07.26

2.0

D6002115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube

Check OD = 2.250"; ID = 1.750"

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

REFERENCE ONLY

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET